
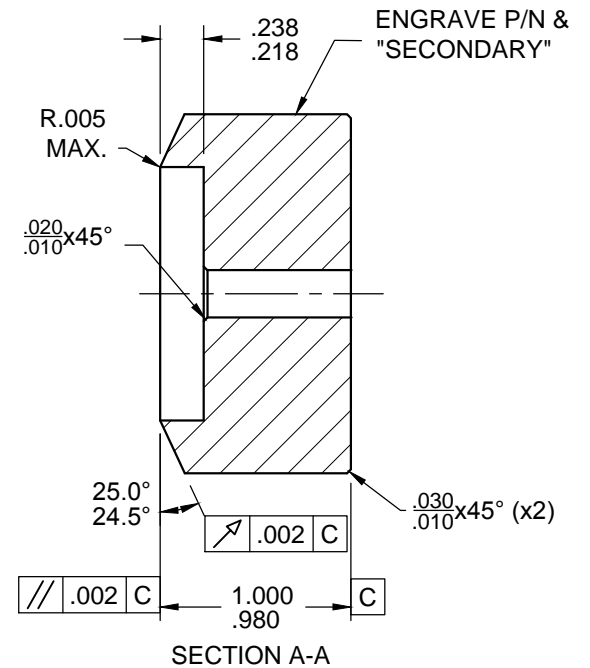
[illegible]


1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE			
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; LOCATING PIN			
DWG NO.		REV	
TOOL# (see chart)-15		2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS .XXX ± .005		HEAT TREAT	
XX ± .01		FINISH SPEC	
X ± .1		BLACK OXIDE	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING	
SCALE NTS		SEE Pg. 1	
DATE 5-10-88		SHEET 9 of 9	

Technical drawing of a secondary seat. The drawing shows a cross-section of a cylindrical part with a central hole. The outer diameter is labeled $\varnothing A$. The inner diameter is labeled $\varnothing B$ P.D. The central hole has a diameter of $\varnothing .249$ and a position feature (P.F.) of -15 . The surface finish is specified as $.005$ A B. The drawing includes a feature control frame with the following information: $\varnothing B$ P.D., REAM, $\varnothing .249$, P.F. -15 , $.005$, A, B. The drawing is labeled -13 and SECONDARY SEAT.




1. BREAK ALL SHARP CORNERS (.015/.03).


 RED BARN MACHINE			
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; SECONDARY SEAT			
DWG NO. TOOL# (see chart)-13			REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 5-1-08	SHEET 8	of 9

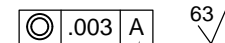
[illegible]

1. BREAK ALL SHARP CORNERS (.015/.03).


 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; PRIMARY SEAT	
DWG NO.	REV 2
TOOL# (see chart)-11	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH BLACK OXIDE SPEC USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 5-10-88
SHEET 7 of 9	

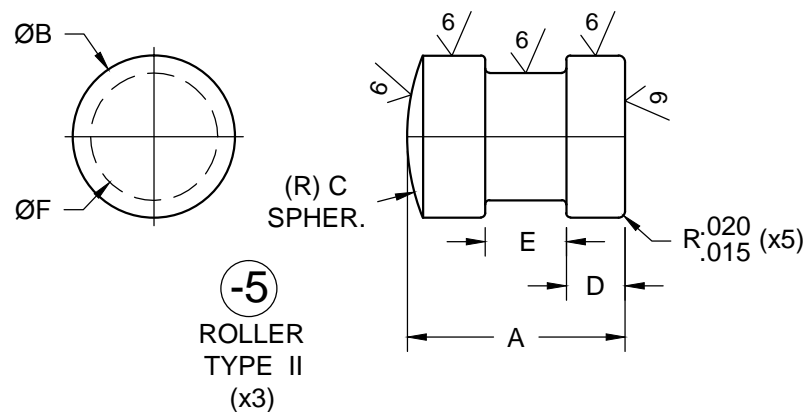



 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; PIN	
DWG NO. TOOL# (see chart)-9	REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 5-1-08
	SHEET 6 of 9

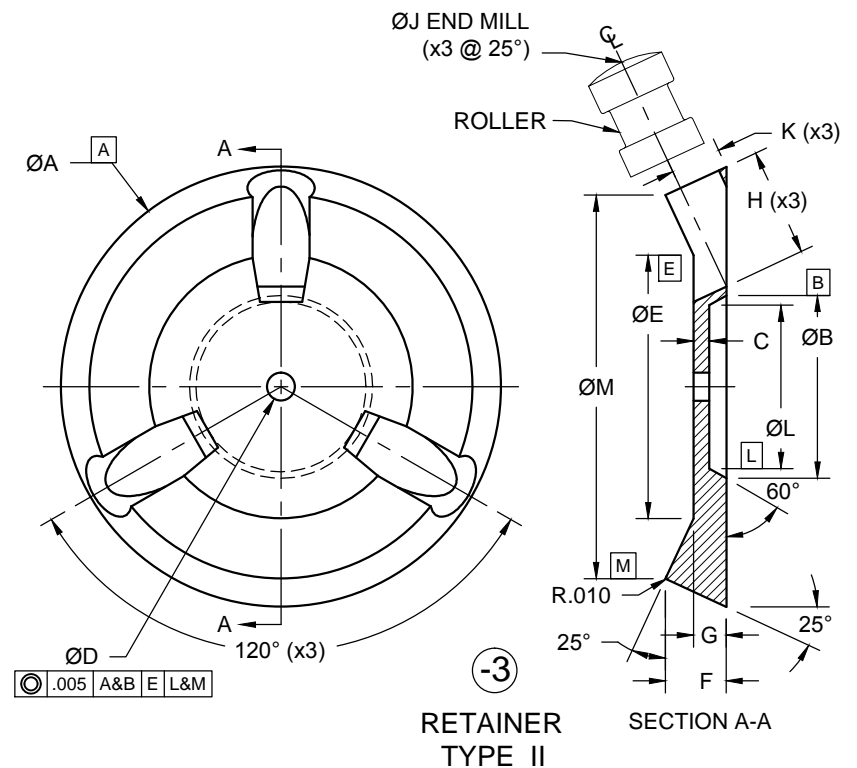


GUIDE


 RED BARN MACHINE			
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; GUIDE			
DWG NO. TOOL# (see chart)-7			REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED _____ HEAT TREAT _____ FINISH SPEC _____	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 ± 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
SCALE NTS	DATE 5-10-88	SHEET 5	of 9



 RED BARN MACHINE	
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; ROLLER (QTY. 3)	
DWG NO.	REV 2
TOOL# (see chart)-5	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING SEE Pg. 1
SCALE NTS	DATE 5-1-08
SHEET 4 of 9	

[illegible]

1. BREAK ALL SHARP CORNERS (.015/.03).


 RED BARN MACHINE			
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; RETAINER			
DWG NO.		REV	
TOOL# (see chart)-3		2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
SCALE	NTS	DATE	SHEET
		5-10-88	3 of 9

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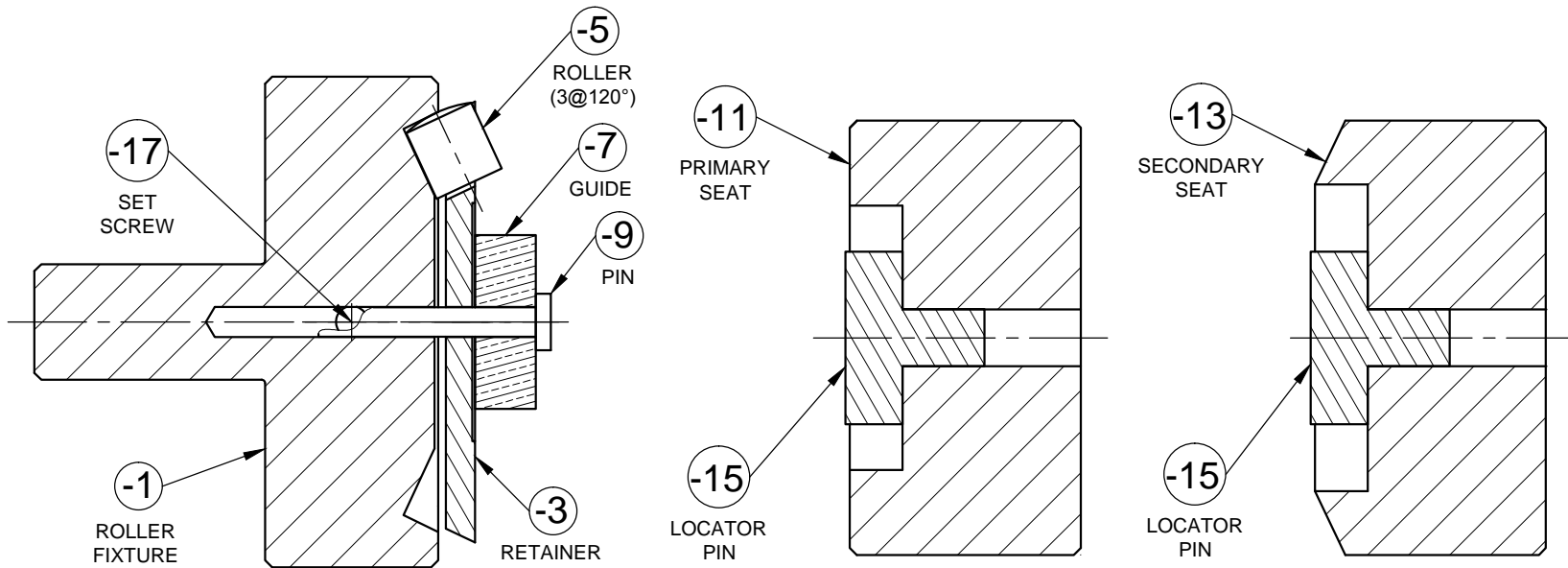


1. BREAK ALL SHARP CORNERS (.015/.03).
2. DIMENSION TO BOTTOM OF R.016 = H DIM.;
DIMENSION TO SHARP CORNER= H DIM.+ .005.
3. -1 BEARING RACE SURFACES MUST HAVE
SMOOTH APPEARANCE, FREE FROM
MACHINING MARKS AND GROOVES.
4. DO FIRST ARTICLE INSPECTION
BEFORE HEAT TREATING.

[illegible]

 RED BARN MACHINE			
TITLE RBST2900 SERIES DP TRI-ROLLER SWAGING TOOL; ROLLER FIXTURE			
DWG NO. TOOL# (see chart)-1			REV 2
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED HEAT TREAT RC 55-60 FINISH BLACK OXIDE SPEC USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 ± 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 5-10-88	SHEET 2 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED -5 ROLLER RADUIS FROM .005 - .010, TO .015 - .020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
1A	CH'D T/N'S FROM KST.	11/20/09	RJC	
2	-1 CH'D TOL. (H) WAS +/- .002 IS +/- .005.	6/17/13	BIM	GE



BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
430-310-205-103	RBST2936
430-310-456-101	RBST2939
430-310-201-101	RBST2940

NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8
		-15	1 or 2	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RED BARN MACHINE

TITLE RBST2900 SERIES DP
TRI-ROLLER SWAGING TOOLS

DWG NO. TOOL # (SEE CHART ABOVE) REV 2

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES ON:
 DECIMALS .XXX ± .005 FRACTIONS ± 1/32
 .XX ± .01 ANGLES ± 5°
 .X ± .1

UNLESS OTHERWISE SPECIFIED
 1. BREAK ALL SHARP EDGES
 .015 x 45° PR .015 R
 2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SCALE NTS DATE 5-1-08 SHEET 1 of 9

DRAWN BY: PERRITT

APPROVED

HEAT TREAT LISTED PER ITEM

FINISH SPEC LISTED PER ITEM


USED ON BEARING

SEE ABOVE

REVISIONS				
REV	DESCRIPTION 2100	DATE	INITIAL	APPROVE
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	CHANGED -15 LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. CHANGED -11 & -13 FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	G.E.
3	ADDED KST2128 & KST2162. REMOVED 25° ANGLE FROM -13 SECONDARY SEAT AND DELETED ØB DIMENSION. ALSO ADDED QTY. TO -13 & -15 CHART.	4/22/08	WP	

REVISIONS				
REV	DESCRIPTION 2000	DATE	INITIAL	APPROVED
1	ADDED TOOL No.'s KST2014 & 2015 & 2017. ALSO ADDED -1 AUX. VEIW & ASSOCIATED DIMENSIONS WITH "J" DIM., CHANGING FROM .153 TO VARIABLE, -3 TYPE II RETAINER & ASSOCIATED DIMENSIONS, -5 TYPE II ROLLER & ASSOCIATED DIMENSIONS, AND VARIABLE QUANTITY TO -13 & -15 PER TOOL.	4/25/08	WP	DW

[illegible]

 RED BARN MACHINE			
TITLE			
<div style="text-align: center;">— —</div>			
DWG NO.			REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°			DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			USED ON MODEL
SCALE	NTS	DATE	SHEET
		8-15-07	1 of 1

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	<div>RB</div> RED BARN MACHINE		
CHECKED	TITLE		
HEAT TREAT FINISH SPEC	TITLE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	DWG NO. PART #		REV.
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS	DATE 1-28-06	SHEET 1 of 1

USED ON MODEL
?